



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3075-1

Job Sheet 176822



Part No: D3075-1

Job Qty: 7 ea

Part Name: Bearpaw (Foot Print Only)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/1/18

Job Tracking No:

Due Date: 5/23/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM IPP Rev:D Added C'Bores as per Rev B 07-03-28 JLM IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC IPP Rev:F 08-11-12 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	5/23/18	5/23/18	0.00	0.00	Start Up Waterjet		ac 18/05/01
110	Waterjet	6 pcs	5/23/18	5/23/18	0.00	0.98	Waterjet1		ac 18/05/01
120	CNC Vertical Machining	6 pcs	5/23/18	5/23/18	0.34	5.50	HAAS1-3		gmsl 18/06/20
140	QC	6 pcs	5/23/18	5/23/18	0.00	0.00	QC8		ac 18/06/28
150	Packaging	6 pcs	5/23/18	5/23/18	0.00	0.00	Packaging3		JUN 28 2018
160	QC21-SA	6 Ea	5/23/18	5/23/18	0.00	0.00	QC21		JUN 28 2018

Part Op 110 - CUT BLANK AS PER FILE D3075-1_BLANK

Descriptions: 120 - Note: (2) Bearpaw for (1) Kit 2-Machine as per Folio FA185 and Dwg D3076 Identify as D3075-1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	6 sf (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	6	1,576	0



Container No: S067592



Part: D3075-1

Job No: 176822

Serial No/Batch: S067592

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/02/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	R44 Bearpaw	0.070Inches + 0.030 - 0.010	0.100 0.060	.060	
2	R44 Bearpaw	45.000Degrees ± 0.000	45.000 45.000	45°	
3	R44 Bearpaw	0.630Degrees ± 0.030	0.660 0.600	.630	
4	R44 Bearpaw	0.250Inches ± 0.010	0.260 0.240	0.240	
5	R44 Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940	0.940	
6	R44 Bearpaw	5.500Inches ± 0.030	5.530 5.470	5.499	
7	R44 Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.260	
8	R44 Bearpaw	45.000Degrees ± 0.000	45.000 45.000	45°	
9	R44 Bearpaw	0.900Inches ± 0.010	0.910 0.890	.904	
10	R44 Bearpaw	0.375Inches ± 0.010	0.385 0.365	.380	
11	R44 Bearpaw	1.300Inches ± 0.030	1.330 1.270	1.300	
12	R44 Bearpaw	5.700Inches ± 0.030	5.730 5.670	5.680	
13	R44 Bearpaw	0.370Inches ± 0.030	0.400 0.340	.370	
14	R44 Bearpaw	3.600Inches ± 0.010	3.610 3.590	3.600	
15	R44 Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	.261	
16	R44 Bearpaw	0.930Inches ± 0.030	0.960 0.900	.927	
17	R44 Bearpaw	0.300Inches + 0.030 - 0.000	0.330 0.300	.320	
18	R44 Bearpaw	1.080Inches ± 0.030	1.110 1.050	1.080	
19	R44 Bearpaw	5.870Inches ± 0.010	5.880 5.860	5.870	
20	R44 Bearpaw	10.140Inches ± 0.030	10.170 10.110	10.14	

Plex 5/1/18 3:11 PM Dart.Gagnon.Michelle